

Work Order ID 56925

April 7, 2010 2:35:27 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 15/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-3-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

[Signature] CL 10/04/14

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature] 10/3/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Draw
Number

Draw
Rev.

Plan
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod *ML13207*

BE 10/03/18

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod *ML13207*

BE 10/03/18

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/03/24

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Number

Draw
Rev.

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Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/03/26



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

8/10/07/26



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

BR 10-4-1 ①

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



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Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:17:00
3:30
320°
14:00

0.00

OK 10-4-5

①.

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10/04/06

(1x) X

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates.
A/R ☐ ☐ ☐ Sikaflex-291 11/24/29
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 11/24/29
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 1113462

BR 10-4-6, D

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Sub 64107

70

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____
PPP Rev: I

10/4/14

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/15

MF

10-4-15

56925

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Work Order ID: 56925



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 15/03/2010

Required Date: 31/03/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 2.0000 1.0000



205 Skidtube bent detail



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

2

54541

2

D2576-3 Manufactured No

140

Each

128.0000

1.0000



Step (maching detail)



1356667: 1 11/13/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

128

46661

81

52215

47

~~1356667~~ 1 10/03/18

Dart Aerospace Ltd

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 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 227.0000 20.0000



Crossbolt Spacer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG	105
51525	4
53780	3
54543	18
56715	80

Main Warehouse

ST	122
43988	4
46434	4
46956	2
47797	9
48272	2
51314	71
51315	30

: B 56878

Handwritten notes and signatures:

- Signature: *[Signature]*
- Date: 10/03/18
- Signature: *[Signature]*
- Date: 10/03/18

W/O:		WORK ORDER CHANGES					
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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 139.0000 1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP6	1	
56613	1	
Main Warehouse		
ST026	138	
50513	1	
50770	1	
51539 ✓	37	
53791	99	

1 BR 10-4-6

AN3-5A Purchased No 200 Each 1,397.000 2.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	1397	
100188 ✓	188	
105057 ✓	1209	

2 BR 10-4-6.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

Purchased

No

200

Each

3,029.000 2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

3029

101291

16

105793

49

110985 ✓

2964

ALS7-1032-130

Purchased

No

200

Each

986.0000 50.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

986

108606

52

111529

130

111779

34

112772 ✓

11

113238 ✓

759

2 PR 10-4-6

50 PR 10-4-6

March 15, 2010 8:46:59 AM

Shop Packet Print

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,293.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	1293	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226 ✓	344	
113644	12	
113749	11	
114103	331	
114108	500	

SD PL 10-N-6.

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 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN960C10L Purchased No 200 Each 388.0000 50.0000



washer



NAS1149C0332R

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 113524. 100

103585 100

Main Warehouse

ST 288

112116 128

112612 160

50. PR 10-4-6

D3566-13 Manufactured No



Gasket

200 Each 68.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 66

53461 ✓ 66

Main Warehouse

ST 2

45717 1

50265 1

1 PR 10-4-6

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 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200

Each

18.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

15

55026

3

55335 ✓

12

Main Warehouse

ST

3

36113

1

46186

1

51260

1

1 R 10-4-6.

W/O:		WORK ORDER CHANGES					
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Start Date: 15/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 25.0000 2.0000
 Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 56825 20
 52512 3
 54480 1
 55011 1
 55320 1
 56532 14

Main Warehouse

ST 5
 46349 1
 51218 1
 51259 3

2 BK 10-4-6.

D3564-11 Manufactured No 200 Each 5.0000 1.0000
 Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP19 56834 3
 55332 3

Main Warehouse

ST 2
 45823 1
 50112 1

1 BK 10-4-6.

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 15, 2010 8:46:59 AM

Page 9

Work Order ID: 56925



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 15/03/2010

Required Date: 31/03/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-13	Manufactured	No	200	Each	29.0000	1.0000
Wearshoe						

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	17	
56285 ✓	17	
Main Warehouse		
ST	12	
45409	2	
46495	10	

1 PR 10-4-6

D3564-9	Manufactured	No	200	Each	14.0000	1.0000
Wearshoe						

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	12	
55334 ✓	12	
Main Warehouse		
ST	2	
44659	1	
45825	1	

1 PR 10-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 15, 2010 8:46:59 AM

Page 10

Work Order ID: 56925



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 15/03/2010

Required Date: 31/03/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by: DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 28.0000 1.0000



Wearshoe



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 2

34806 2

Main Warehouse

FP19 25

51925 1

55024 12

55333 12

Main Warehouse

ST 1

45824 1

D2594-3 Manufactured No 200 Each 420.0000 16.0000



O-Ring, 205 Skidtube



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 407

51613 27

55546 380

Main Warehouse

ST 13

52562 13

March 15, 2010 8:46:59 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 15, 2010 8:46:59 AM

Page 11

Work Order ID: 56925



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 15/03/2010

Required Date: 31/03/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1 Manufactured No 200 Each 513.0000 16.0000



Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	385	
54008	1	
54643	15	
55002 ✓	369	
Main Warehouse		
ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

16.00 10-4-6

DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 [Signature]

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 51925
2110-3-14

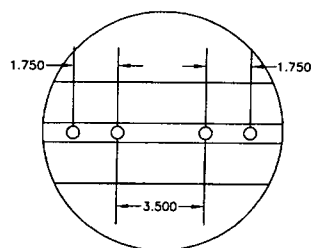
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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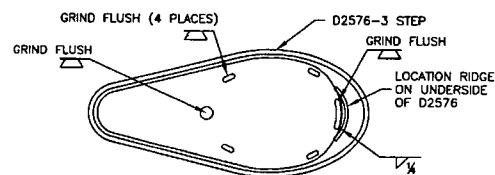
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DETAIL A
SCALE 5:24

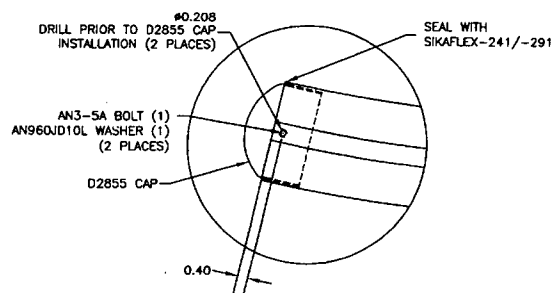


RELEASED
07-06-28-11

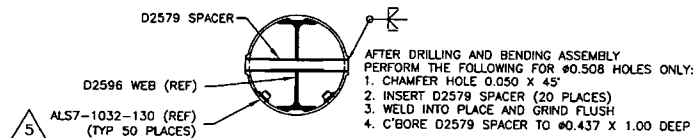
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



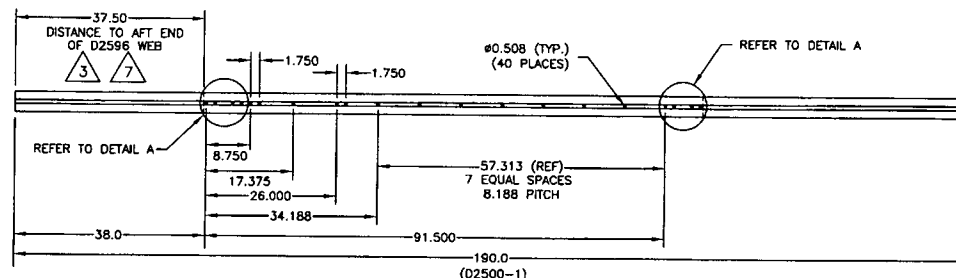
SECTION D-D
SCALE 5:24



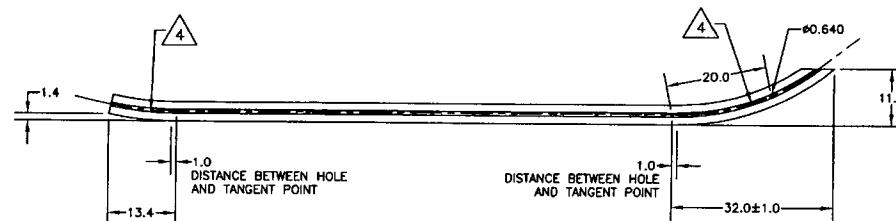
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

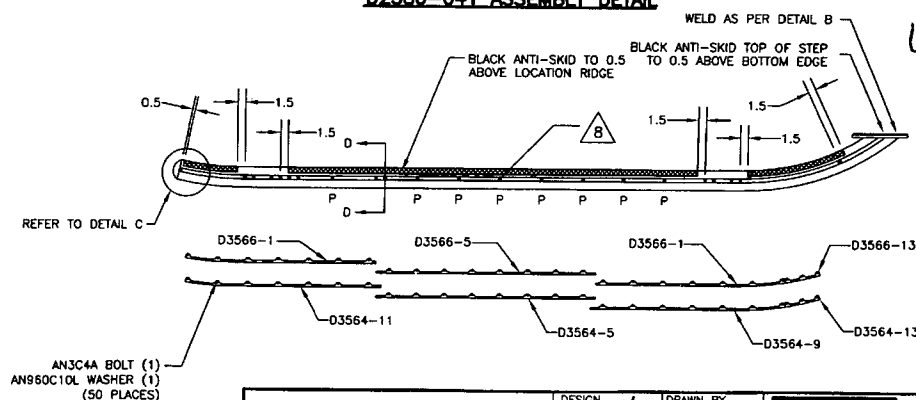
D2580-1 DRILLING DETAIL

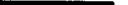


D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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	CHECKED	APPROVED		DRAWING NO.	REV. C
				D2580	SHEET 2 OF 3
	DATE			TITLE	SCALE
	07.02.27			205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07-06-28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

SEAL WITH
SIKAFLEX-241/-291

SEE NOTE ii)

0.40

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP 50 PLACES)

PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø.437 X 1.00 DEEP

5

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible]

Figure 1 is a plan view of the proposed road layout. It shows the alignment of the road, including the existing road, proposed road, and proposed road widening. The diagram includes various dimensions and labels:

- 5.985: Dimension from the existing road centerline to the proposed road centerline.
- 5.338 (REF): Reference dimension for the proposed road centerline.
- 51.340: Total length of the proposed road segment.
- 39.580: Length of the proposed road segment from the existing road centerline to the proposed road widening.
- 5.915: Dimension from the proposed road centerline to the proposed road widening.
- 3.630 (REF): Reference dimension for the proposed road widening.
- 0.508 (8 PLACES): Dimension for the proposed road widening.
- 20.0: Dimension for the proposed road widening.
- 0.640: Dimension for the proposed road widening.
- 1.4: Dimension for the proposed road widening.
- 1.0: Dimension for the proposed road widening.
- 13.4: Dimension for the proposed road widening.
- 32.0 ± 1.0: Dimension for the proposed road widening.
- 11.0: Dimension for the proposed road widening.
- 1.0: Distance between the hole and the tangent point.

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

8

D3566-1, **D3566-5**, **D3566-9**, **D3564-11**, **D3564-5**, **D3564-9**, **D3564-13**

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

P P P P P P P

H H

0.5 1.5 1.5 1.5 1.5 1.5 1.5

REFER TO DETAIL G

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14

DATE
07.02.27

Re

APPROVED

1

DART

DRAWING NO.

02580

TITLE

205 SKIDTUBE ASSEMBLY

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

PEV D

SHEET 3 OF 3

SCALE

1.34

NO. 227

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 56925
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Paul Davis Date of Test Coupon 0.03.19

Welder Barday Elliott Date of Test Coupon 16-03-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld